

Work Order ID 56058

February 9, 2010 1:25:15 PM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 2/09/10

Start Qty: 4.00



Cust Item ID:

Required Date: 2/15/10

Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 10-2-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2530

Rev B

100



Small Fab

Small Fab

Small Fab

Memo

1-Cut to length as per Dwg D2536
2-Deburr

0.00

0.00 SAD 10-02-25

(12)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/2/25

(12)

120



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: M109213

Small Fab

Memo

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

0.00

0.00

(12)

2pl 10-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56058

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Item ID: D2530

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Item Name: Handle Weldment

Start Date: 2/09/10 Start Qty: 4.00

Required Date: 2/15/10 Req'd Qty: 4.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

(12) 10.03.16

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/03/16

(12)

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:30AM

=) 10/03/18

(X/2) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56058

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Item ID: D2530

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Setup Start



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Start Date: 2/09/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-3-18

(12)

4

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 508

0.00

Memo

0.00

10/03/19 (12)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24

CL 10/3/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 9, 2010 1:25:19 PM

Page 1

Work Order ID: 56058

Parent Item: D2530

Parent Item Name: Handle Weldment

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

Start Date: 2/09/10

Required Date: 2/15/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

252.7810

12.2716



304 RD Tube .750 x .049W

each=3.0679 sq(Ft)

SAD 10-02-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

252.781

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

34.39

112800

185.931

✓ 36.8148

D2534

Manufactured

No

120

Each

20.0000

8.0000



Lock Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST017

10

52569

10

Main Warehouse

WA

10

55329

10

10 lpc

14 lpc

B56552 →

Cpl 10-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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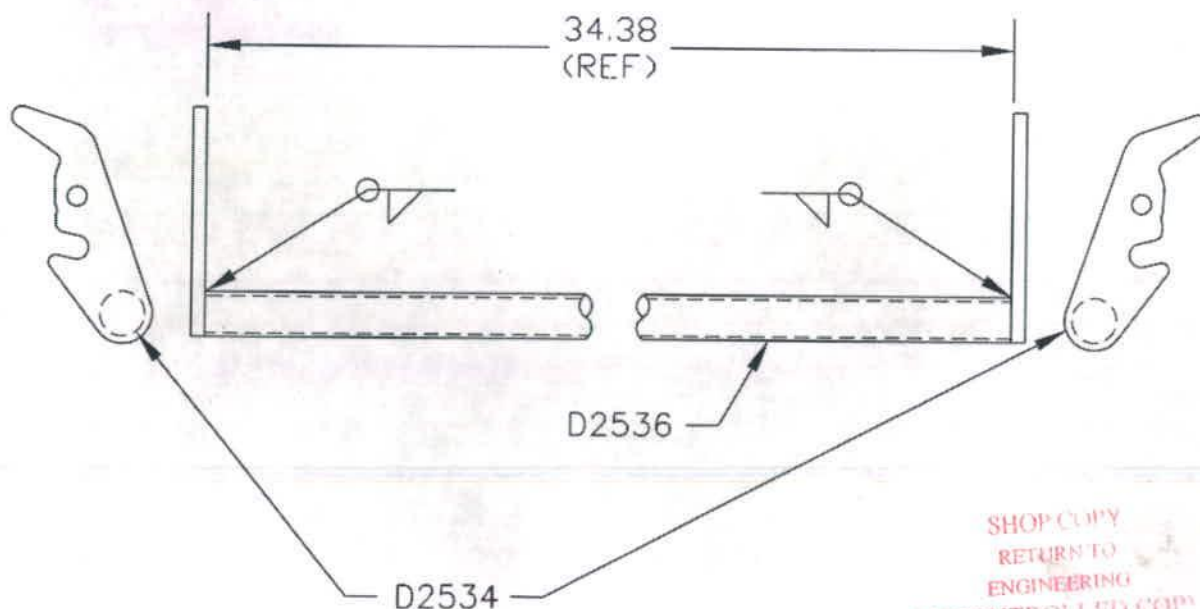
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2530	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	SHEET 1 OF 1	
DATE 04.12.14	TITLE HANDLE WELDMENT	SCALE	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56058
BN 10-2-00

